

Work Order ID 63387

Thursday, October 28, 2010 10:51:06 AM



Page 1

Item ID: K642-511	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: saddle kit 642-511					
Start Date: 10/28/2010	Start Qty: 4.00		Cust Item ID:		
Required Date: 11/12/2010	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 10-10-25	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9467	Rev A
IIN D206-642	Rev N

100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Create White labels per PPP K642-511	CHG004							
110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

10-10-25 (4)

10/11/25 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 63387

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Item ID: K642-511

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-511

Start Date: 10/28/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

10/28/09 10 12 09 (4)

130



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP K642-511 Location: PK

REV B

10/12/09 sf (4)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/09 MF 10-12-09

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Page 1

Work Order ID: 63387

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 07.06.05 new issue EC
IPP Rev.B 08.02.05, Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C35A BOLT		Purchased	No			110	Each	68.0000	3	12			
-----------------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST353	68	
109323	6	
111724	1	
112489	31	
114523	30	

AN3C36A BOLT		Purchased	No			110	Each	115.0000	9	36			
-----------------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST353	115	
109771	10	
115358	15	
115518	40	
115882	50	

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

AN3C41A
BOLT

Purchased No

110

Each

111.0000

8

32

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

107

108084

7

108409

8

112879

1

114443

59

115316

32

M114443 8X
M115316 24

Purchased No

110

Each

535.0000

12

48

Location

Loc Qty

Loc Code

FG

4

103344

4

ST

4

103344

0

111295

4

ST356

527

113121

127

115016

200

116003

200

M113121 10X
M115016 28X

M116075 10X (4)

AN4C6A
Bolt

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

AN5C11A
Bolt

Purchased No 110 Each 204.0000

8 32 ✓
M116075

Location	Loc Qty	Loc Code
FG	4	
104817	4	
ST338	200	
108428	8	
109898	8	
114443	14	
114455	70	
114523	100	

AN5C12A

Purchased No 110 Each 64.0000

4 16
M114823
M116075

Location	Loc Qty	Loc Code
FG	2	
18918	2	
ST338	62	
113121	62	

AN5C13A

Purchased No 110 Each 82.0000

4 16
M114430 (4)

Location	Loc Qty	Loc Code
FG	2	
18918	2	
ST338	80	
111648	1	
113121	29	
114615	50	

M113121 2x
M114615 13x

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

MJM
X4
AN5C15A

Bolt

Purchased No

110

Each

81.0000

1

4

L

Location

Loc Qty

Loc Code

ST339

81

111819

81

Purchased No

110

Each

90.0000

2

8

M111815

L

Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

86

107013

1

107463

2

111808

33

113164

50

M111808

Purchased No

110

Each

104.0000

2

8

L 10/14/30

Location

Loc Qty

Loc Code

FG

2

18918

2

ST340

102

107289

2

110342

2

111648

38

112454

60

M111648

MJM
X4
AN5C34A

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Parent Item Name: saddle kit 642-511

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

AN5C35A

Purchased

No

110

Each

93.0000

1

4

Location

Loc Qty

Loc Code

ST340

93

107551

2

108084

45

108407

46

m108084

AN960C10L

NAS1149C0332

Purchased

No

110

Each

29.0000

24

96

Location

Loc Qty

Loc Code

ST245

29

107534

29

AN960C446L

NAS1149C0332

Purchased

No

110

Each

164.0000

24

96

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

120

106785

10

107008

10

112612

3

112794

29

112828

27

69220

41

m114742

10/11/09 (4)

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Parent Item Name: saddle kit 642-511

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

AN960C5161

NAS1149C0532

Purchased

No

110

Each

22.0000

8

32



WASHER



M115531

[Handwritten signature]

Location

Loc Qty

Loc Code

ST347

22

103344

8

109545

8

111916

6

D206-648-013

Manufactured

No

110

Each

10.0000

1

4



GHW Modification



63860

[Handwritten signature]

Location

Loc Qty

Loc Code

FG120

10

42315

1

47600

1

62644

8

D2652

Manufactured

No

110

Each

151.0000

16

64



Bushing



63991

[Handwritten signature]

Location

Loc Qty

Loc Code

FG

44

31985

44

ST020

107

61645

1

62659

106

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

D2712

Set Screw

Manufactured No

110

Each

413.0000

10

40

Location

Loc Qty

Loc Code

FG

50

29962

50

ST022

363

61331

363

Manufactured No

110

Each

4.0000

1

4

Location

Loc Qty

Loc Code

ST421

4

45262

1

62687

3

Manufactured No

110

Each

8.0000

1

4

D2933-1

Saddle LH In, 206

Location

Loc Qty

Loc Code

ST421

5

42978

1

62693

4

ST428

3

60904

3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 63387

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

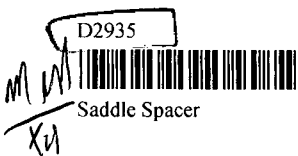


Manufactured No 110 Each 20.0000

2 8
63559

Location Loc Qty Loc Code

FG 6
31929 6
ST031 14
59641 14

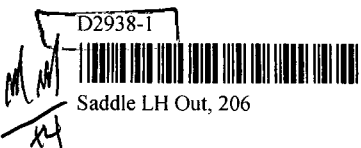


Manufactured No 110 Each 51.0000

2 8

Location Loc Qty Loc Code

ST028 51
59642 6
62690 45



Manufactured No 110 Each 5.0000

4
62690
62059 10/4/29 (4)

Location Loc Qty Loc Code

ST421 4
44554 1
62695 3
ST428A 1
60905 1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 63387

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

D2939-1

Saddle LH In, 206

Manufactured No

110 Each

4.0000



4

62060

[Handwritten signature]

Location

Loc Qty

Loc Code

ST421

3

43188

1

62628

2

ST428A

1

58534

1

Manufactured No

110 Each

31.0000



8

63557

[Handwritten signature]

D3396-3

Spacer

Location

Loc Qty

Loc Code

FG

10

26772

10

ST055

21

36336

2

45667

2

58680

17

Manufactured No

110 Each

15.0000



4

63557

[Handwritten signature]

D3407-043

Tow Ring

Location

Loc Qty

Loc Code

ST420

8

62627

8

ST464

7

50387

7

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 63387

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

D3456-1

Washer

Manufactured No

110

Each

3.0000

Location

Loc Qty

Loc Code

ST058

3

54692

3

Manufactured No

110

Each

13.0000

Location

Loc Qty

Loc Code

FG

10

32409

10

ST059

3

45913

1

52981

2

Manufactured No

110

Each

847.0000

Location

Loc Qty

Loc Code

ST077

847

42329

150

52505

697

Manufactured No

110

Each

559.0000

Location

Loc Qty

Loc Code

ST077

559

47023

16

55500

32

57704

511

D3672-1

Phenolic Washer

Manufactured No

110

Each

847.0000

Location

Loc Qty

Loc Code

ST077

847

42329

150

52505

697

Manufactured No

110

Each

559.0000

Location

Loc Qty

Loc Code

ST077

559

47023

16

55500

32

57704

511

D3672-3

Phenolic Washer

Manufactured No

110

Each

559.0000

Location

Loc Qty

Loc Code

ST077

559

47023

16

55500

32

57704

511

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Parent Item: K642-511

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Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

D3672-7

Phenolic Washer

Manufactured No

110

Each

556.0000

24

96

Location

Loc Qty

Loc Code

ST077

556

35522

8

51696

16

53237

532

53237

Purchased

No

110

Each

2,506.000

20

80

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2430

112314

2430

M112314

Purchased

No

110

Each

946.0000

13

52

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

906

112492

25

113069

8

114181

29

114523

244

114784

300

115936

300

M114523 18X
M114784 34X

MS21043-4

Nut

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Work Order ID: 63387

Parent Item: K642-511

Parent Item Name: saddle kit 642-511



Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

110

Each

580.0000

4

16 ✓



Nut



Ce 10/11/29 (4)

Location

Loc Qty

Loc Code

ST301

580

111819

80

112314

500

11/18/9

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32.17 206L/L-1/L-3/L-4/407 High Gear Float Skidtubes (Tri-Bag Compatible) Parts List

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			AN3C4A	* BOLT ⁽¹⁾
5A			2			AN960C10L	* WASHER ⁽¹⁾
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (OR AN5C12A)	* BOLT ⁽²⁾
14	4	4				AN5C11A (OR AN5C13A)	* BOLT ⁽²⁾
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET ⁽¹⁾
23A			1	1		D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET ⁽¹⁾
24A			1	1		D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET ⁽¹⁾
25A			1	1		D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET ⁽¹⁾
26A			78	78		AN3C4A	* BOLT ⁽¹⁾
26B			78	78		AN960C10L	* WASHER ⁽¹⁾
26C			78			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE

(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)